

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004321**Date Inspected:** 25-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

Longitudinal Diaphragm Visual Inspection

The Quality Assurance Inspector performed a preliminary visual inspection of longitudinal diaphragms for the purpose of the internal American Bridge/Fluor green tagging system in the OBG Assembly Bay. The Inspection performed only included the sub-assembly and did not include the longitudinal diaphragm to bottom plate connection. Six of the eight sub-assemblies the Quality Assurance Inspector observed appeared to meet the contract requirements. The Quality Assurance Inspector made ZPMC aware of several areas with undersized fillet welds and base metal anomalies in need of repair. ZPMC Quality Control Inspector Wang Dong marked the areas for repair and relayed the issues would be repaired. Quality Assurance Inspectors Tim McClendon and Raymond Lara followed the visual inspection with the 10 percent magnetic particle testing required.

Summary of Conversations:

As stated in the contents of the above report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann 1500.2199.593, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspected By:	Bertlesman,Greg	Quality Assurance Inspector
----------------------	-----------------	-----------------------------

Reviewed By:	Wright,Mark	QA Reviewer
---------------------	-------------	-------------
